

Date: Thursday, 4/5/2007 11:58:53 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB  
 Job Number : 31689  
 Estimate Number : 10195  
 P.O. Number : N/A Part Number : D21741  
 This Issue : 4/5/2007 S.O. No. : N/A Drawing Number : D2174-1 REV E  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : E  
 Previous Run : 30870 Material : N/A  
 Due Date : 4/30/2007 Qty: 36 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est C 04/06/09 Reformat KJ/RF  
 Est Rev:D As per Rev E 06-11-22 JLM

## Additional Product

Job Number:  
 sk



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.4958 sf(s)/Unit Total : 14.8743 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: M103321

SAD 07/05/17

36

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2174

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

SAD 07/05/17

36

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/17

36

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

705-22 (36)  
 count

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

MF 07-05-23

(36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/24

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:58:53 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 31689

Part Number: D21741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/23 (36)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL/BR

07/05/24 (36)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

PC 7/5/24 (36)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC 7/5/24 36

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/24 (36)

Job Completion



U 07/05/24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	31689
Description: Web		Part Number:	D2174-1
Inspection Dwg: D2174 Rev: E		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.258	✓		Vern	
6.400	+/-0.010	6.400	✓		Vern	
4.800	+/-0.010	4.806	✓		Vern	
1.375	+/-0.010	1.383	✓		Vern	
1.050	+/-0.005	1.048	✓		Vern	
Ø0.128	+0.005/-0.001	Ø0.129	✓		Vern	
12.650	+/-0.010	12.650	✓		M-T	
0.550	+/-0.010	0.550	✓		Vern	
0.900	+/-0.010	0.906	✓		height gauge	
1.629	+/-0.010	1.633	✓		Vern	
1.506	+/-0.005	1.507	✓		Vern	
11.550	+/-0.005	11.547	✓		Vern	
50°	+/-0.5°	50°	✓		Angle	
0.063 thick	+/-0.010	0.063	✓		Vern	
Ø0.172	+0.005/-0.001	Ø0.174	✓		Vern	
0.063	+/-0.010	0.061	✓		Vern	

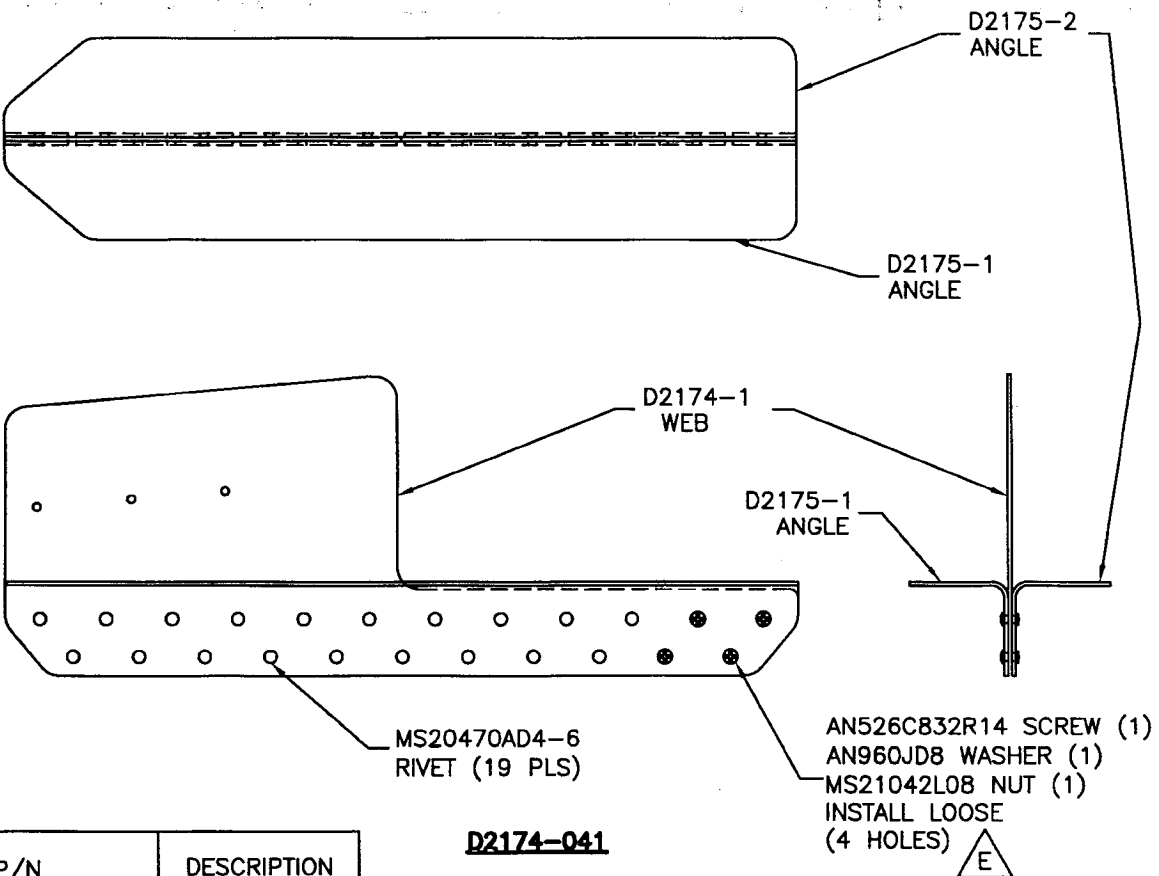
Measured by:	SAD	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	07/05/17	Date:	0705-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	[Signature]





DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
RF	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED CH	DRAWING NO. D2174	SHEET 1 OF 2
DATE 06.09.25	TITLE WEB ASSEMBLY	SCALE 1:3	
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



**D2174-041**

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WITHOUT NOTICE  
NO. 31689  
WORK ORDER

RELEASED  
06.10.13

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

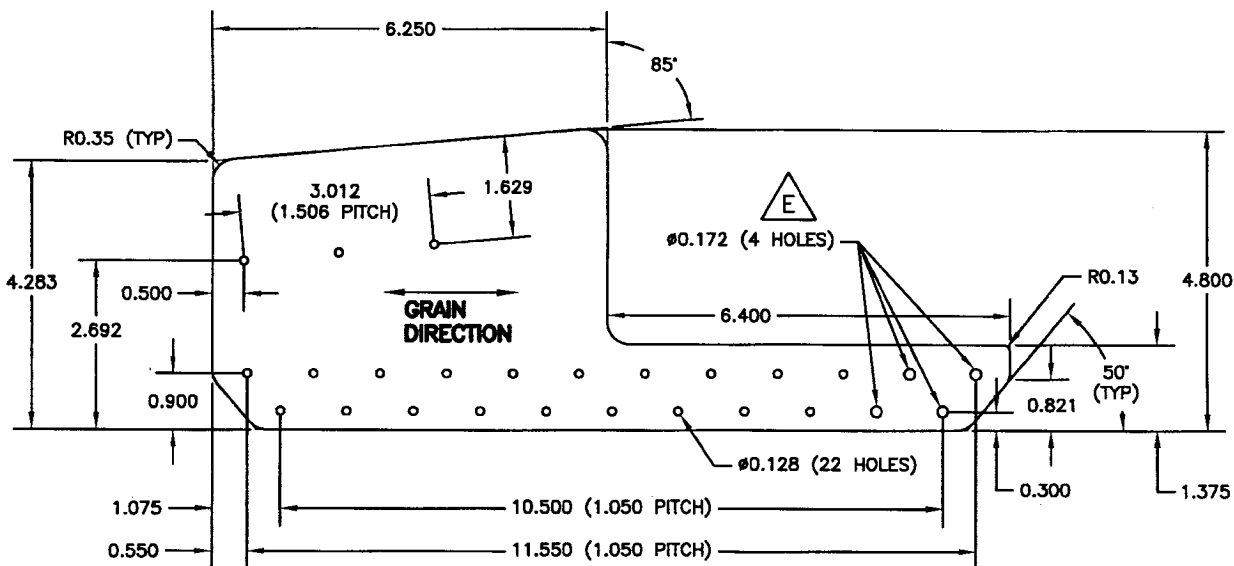
**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	CE	DRAWING NO.	REV. E
CHECKED PH	APPROVED [Signature]	D2174	SHEET 2 OF 2
DATE 06.09.25		TITLE WEB	SCALE 1:3

RELEASED  
06.10.23



D2174-1

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

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